

Date: Monday, 7/9/2007 11:47:02 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TOW RING
Job Number : 33362	
Estimate Number : 12928	
P.O. Number : N/A	Part Number : D2968043UP
This Issue : 7/9/2007 S.O. No. : N/A	Drawing Number : D2968
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : BY C RH
Previous Run : N/A	Material : N/A 07-07-09
Written By : <u>JA 07.07.09</u>	Due Date : 7/20/2007 Qty: 12 Um: Each
Checked & Approved By : <u>JA 07.07.09</u>	
Comment : Est Rev:A New Issue 07-07-04 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	33362A	STEM
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Comment: Sub-Component STEM
 D2968-3 B 33362-A

JA 07/09/09

2.0	33362B	RING
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Comment: Sub-Component RING
 D2968-5 B 30275

JA 07/09/09

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1
 Weld D2968-3 & D2968-5 as per Dwg D2968 & QSI 004 using 4130 welding rod Identify as D2968-043
 Batch: M102421

JA 07/09/09

4.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

JA 07/09/10

5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

JA 07/09/10

6.0	OUTSIDE SERV.30	OUTSIDE SERVICES-MACH
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Comment: Sub-Contracting PURCHASING
 Issue P/O: 4547
 Description: D2968-043 to heat treat to ultimate tensile strength
 125ksi as per Dwg D2968
 Conformity sheet required

CLO 7/09/10

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: 12 Date: 07/10/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 11:47:02 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOW RING

Job Number: 33362

Part Number: D2968043UP

Job Number:



Seq. #:

Machine Or Operation:

Description :

Issue P/O: 4548

C207/09/10

Cad Plate per QQ-P-416F Class I Type II

Conformity sheet required

(12)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

C207/10/03 (12)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

C207/10/09 counter (12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

C207/10/09 (12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

C207/10/11 (12)

Job Completion



C207/10/10

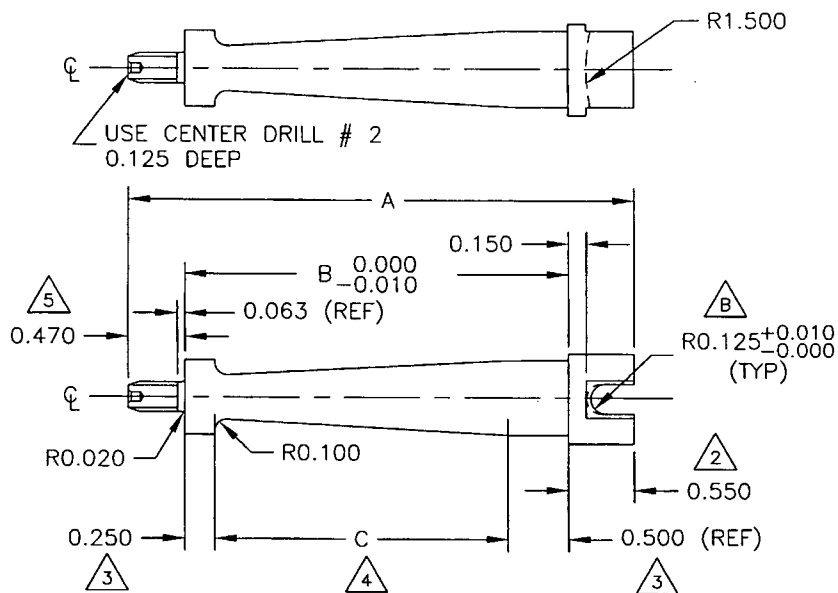
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



PART NUMBER	A	B	C
D2968-1	5.040	4.020	3.270
D2968-3	4.200	3.180	2.430

D2968-1/-3 STEM

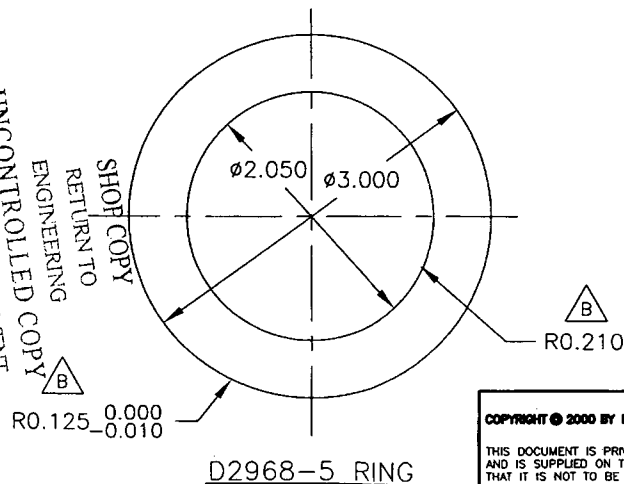
D2968-1 AND D2968-3 STEM:

- 1) MATERIAL: AISI 4130N ROUND BAR PER MIL-S-6758
OR AMS 6348/6370/6528
(REF DART SPEC M4130N-RX.XXX)
- 2) $\phi 0.750$ O.D.
- 3) $\phi 0.625$ O.D.
- 4) MACHINE UNIFORM TAPER FROM $\phi 0.363$ O.D.
TO $\phi 0.625$ O.D.
- 5) 1/4-28 UNF THREAD WITH 0.063 GRIP
- 6) MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
UNLESS OTHERWISE INDICATED
- 7) ALL DIMENSIONS ARE IN INCHES
- 8) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

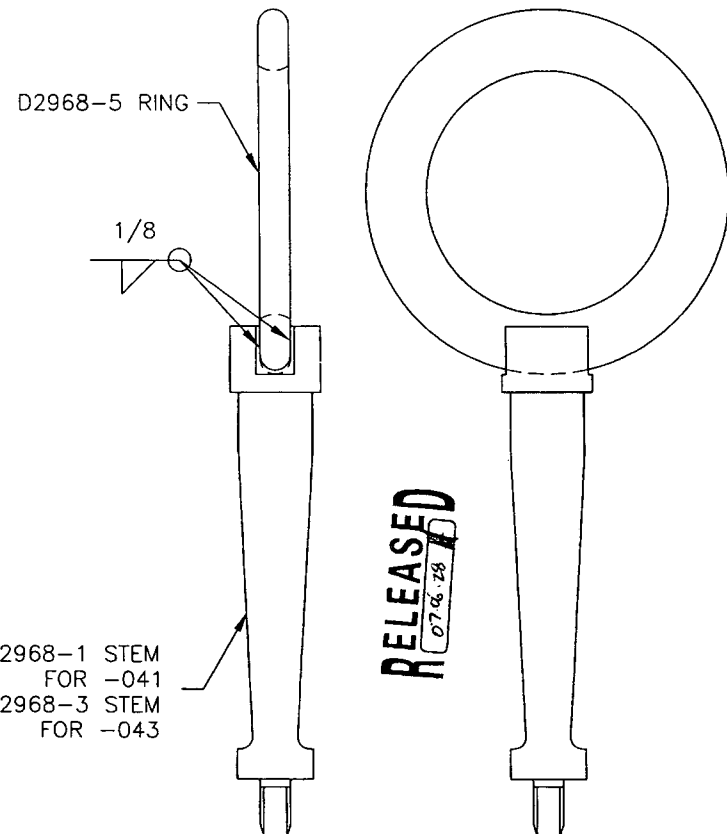
D2968-5 RING:

- 9) MATERIAL: AISI 4130N TUBING PER MIL-T-6736
OR AMS 6360/6361/6362/6371/6373/6374
(REF DART SPEC M4130NT3000W500)

- 10) ALL DIMENSIONS ARE IN INCHES
- 11) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2968-5 RING



D2968-041 AND D2968-043 TOW RING:

- 12) WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING
- 13) HEAT TREAT TO MIN ULTIMATE TENSILE STRENGTH OF 125 KSI
- 14) FINISH: CAD PLATE ENTIRE ASSEMBLY PER
QQ-P-416F CLASS I TYPE II
POWDER COAT WHITE (REF 4.3.5.2) PER DART
QSI 005 4.3 (EXCEPT THREADS)

C	07.04.17	2.050 WAS 2.000, UPDATE NOTES
B	00.05.31	R0.125 AND R0.210 WERE 0.060 x 45°
A	00.03.07	NEW ISSUE
DESIGN	<i>[Signature]</i>	DRAWN BY <i>[Signature]</i>
CHECKED	<i>[Signature]</i>	APPROVED <i>[Signature]</i>
DATE	07.04.17	TOW RING
DART	DART AEROSPACE LTD.	WARRICKS, ONTARIO, CANADA
DRAWING NO.	D2968	REV. C
TITLE	TOW RING	SHEET 1 OF 1
SCALE	1:1	

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WITHOUT NOTICE

Placage

Manco Domplex Electroplating

Siège social / Head Office Plan 1
4660 Hickmore 4670 Hickmore
Ville St-Laurent, Québec Ville St-Laurent, Québec
H4T 1K2 Fax: (514) 355-5991
Fax: (514) 355-8750

Plan 2
8001 Larrey
Anjou, Québec
Fax: (514) 354-2937

**BON DE LIVRAISON
PACKING SLIP**

Tél.: (514) 355-7867 / 1-877-355-7867

V E N D U S O L D T O

EXPÉDIENT

DART AVENUE/100 LTJ
1270 ALABAMA ST
STARKESBURG, GA 30914

[illegible]

AUCUNE RÉCLAMATION APRÈS 5 JOURS DE LA DATE DE LIVRAISON
NO CLAIMS AFTER 5 DAYS FROM DATE OF DELIVERY

COPIE BLANCHE / WHITE COPY: BUREAU / OFFICE - COPIE VERTE / GREEN COPY: CONFIRMATION D'EXPÉDITION / SHIPPING CONFIRMATION
COPIE ORANGE / ORANGE COPY: CLIENT / CUSTOMER - COPIE BLEU / BLUE COPY: FICHE D'EXPÉDITION / SHIPPING FILE

BON DE LIVRAISON
105843

MANCO DOMPLEX

8895 Crescent 3
Anjou (Québec) H1J 1B6
Tél.: 514-355-7867
Fax: 514-355-8750

CERTIFICAT DE CONFORMITÉ CERTIFICATE OF COMPLIANCE

19013

DART AEROSPACE LTD
Client / Customer

D2968-043 WP B3336
de la pièce / part

104548
Votre # de commande / Your purchase order #

105843
Notre # de bon de livraison / Our packing slip #

Inspecteur / Inspector	<u>RENAN LT</u>	Date, équipe / Date, shift	<u>SEPT 28, 2007</u>
Placage / Plating	<u>QQP 416 F. CLASS 1 TYPE II</u>		
Quantité totale / Total quantity	<u>12</u>	Quantité inspectée / Inspected quantity	<u>12</u>
Adhésion / Adhesion	<u>Good</u>		
Épaisseur / Thickness	L.C.D.	H.C.D.	Moy. / aver. <u>0.0005</u>
Coulisses, taches / Leach, spots	<u>no</u>	Rugosité / Roughness	<u>no</u>
Quantité approuvée / Approved quantity	<u>12</u>	Quantité rejetée / Rejected quantity	

Commentaires / Comments

Nous certifions que les pièces énumérées ci-dessus ont été faites en conformité avec vos dessins et spécifications et rencontrent les exigences contenues dans ces dessins et/ou spécifications.

We hereby certify that the parts listed above have been made in accordance with your drawings and specifications and are correct to the requirements contained in those drawings and/or specifications.

Signé au nom de
Signed on behalf of

**MANCO
DOMPLEX**



VAC AERO

INTERNATIONAL INC.

PACKING SLIP

OAK 90865-1



HEAD OFFICE
1371 SPEERS ROAD, OAKVILLE, ONTARIO
CANADA L6L 2X5
TEL: (905) 827-4171 FAX: (905) 827-7489



QUEBEC DIVISION
7450 RUE VÉRITÉ STREET, ST. LAURENT, QUÉBEC
CANADA H4S 1C5
TEL: (514) 334-4240 FAX: (514) 334-6269

GST No. : R105468102

09/26/2007

MM / DD / YYYY

PAGE : 1

1DAR01

BILL TO: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

SHIP TO: MANCO DOMPLEX
4660 HICKMORE
ST. LAURENT QC

K6A 1K7

H4T 1K2

DATE SHIPPED	SHIP VIA	F.O.B.
09/26/2007	PUROLATOR# 7684382	ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
00004540		COD

LN	PART NO	DESCRIPTION	UOM	QTY ORDERED	QTY SHIPPED	B/O QTY
01	D2968-043	UP B33362	EA	12	12	0
		Process Specifications: Procedure: 4047 HEAT TREATED TO 125 KSI MIN. 100% HARDNESS TESTED PER ASTM E-18, . HRC 27-32.5 MATERIAL: 4130				
02	MC	MINIMUM CHARGE		1	1	0

No claims for shortage in weight or count will be entertained, unless presented within 5 working days after receipt of materials by customer.



VACUUM BRAZING · HEAT TREATING · SPECIAL PROCESSING · FURNACE EQUIPMENT
TURBINE COMPONENT OVERHAUL · PLASMA AND OTHER COATINGS



RELEASE NOTE



GST No. : R105468102

OAK 90865-1

09/26/2007

MM / DD / YYYY

PAGE : 1

HEAD OFFICE
1371 SPERS ROAD, OAKVILLE, ONTARIO
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2009 WYECROFT ROAD, UNIT B
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CANADA L6L 6J4
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QUEBEC DIVISION
7450 RUE VERITE STREET, ST. LAURENT, QUEBEC
CANADA H4S 1C5
TEL: (514) 334-4240 FAX: (514) 334-6269

1DAR01
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

SHIP TO : MANCO COMPLEX
4660 HICKMORE
ST. LAURENT QC

H4T 1K2

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
09/25/2007	PUROLATOR# 7684382	ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
00004547		COD

PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
22068-043	UP B33362	EA	12	12	

Process Specifications:
HEAT TREATED TO 125 KSI MIN.
100% HARDNESS TESTED PER ASTM E-18, HRC 27-32.5
MATERIAL: 4130

Procedure: 4047

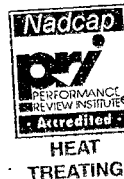
100% HARDNESS TESTED
2 AS
31/32 HRC



I hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant thereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.

Diana Robinson
Authorized Q.C. Inspector



VACUUM BRAZING - HEAT TREATING - SPECIAL PROCESSING - FURNACE EQUIPMENT
PLASMA AND OTHER COATINGS